



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D130-1048-042**  
**Job Sheet 185581**

Accounting Job RD17-1048-01



**Part No:** D130-1048-042

**Job Qty:** 1 ea

**Part Name:** EC130 Skidtube Assembly, RH



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 10/30/18

**Job Tracking No:**

**Due Date:** 11/13/18

**Created By:** Jesse White

**Type:** R+D

**Description:**

**Note:** DWG D130-1048-042 REV.A IPP REV:A 18.08.15 new issue DP Verify DD

**Ship Via:**

**Bill of Materials**



**Container No:** S123017



**Part:** D130-1048-042

**Job No:** 185581

**Serial No/Batch:** S123017

**Revision:** A

**Inspector:**

**Exp Date:**

**Instructions:**

**Date:** 10/31/18

1270 ABERDEEN ST  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

| Job Routing |                    |       |            |          |           |         |                       |           |
|-------------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|
| Op No       | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           |
|             |                    |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |
| 90          | Start up Operation | 1 Ea  | 11/13/18   |          | 0.00      | 0.00    | Start Up Skid tubes-3 |           |
| 150         | Skid tubes         | 1 pcs | 11/13/18   |          | 0.00      | 1.00    | Skid tubes-2          |           |
| 160         | QC                 | 1 pcs | 11/13/18   |          | 0.00      | 0.00    | QC5                   |           |
| 162         | HandFinish         | 1 pcs | 11/13/18   |          | 0.00      | 0.50    | HandFinish6           |           |
| 164         | QC                 | 1 pcs | 11/13/18   |          | 0.00      | 0.00    | QC7-5                 |           |
| 166         | Outsource          | 1 pcs | 11/13/18   |          | 0.00      | 0.00    | Outsource2            |           |
| 170         | Packaging          | 1 pcs | 11/13/18   |          | 0.00      | 0.00    | Packaging2            |           |
| 180         | QC                 | 1 pcs | 11/13/18   |          | 0.00      | 0.00    | QC6                   |           |
| 182         | SprayPaint         | 1 pcs | 11/13/18   |          | 0.00      | 1.00    | Spray Paint           |           |
| 184         | QC                 | 1 pcs | 11/13/18   |          | 0.00      | 0.00    | QC14                  |           |
| 190         | HandFinish         | 1 pcs | 11/13/18   |          | 0.00      | 1.00    | HandFinish4           |           |
| 200         | QC                 | 1 pcs | 11/13/18   |          | 0.00      | 0.00    | QC5                   |           |
| 230         | SprayPaint         | 1 pcs | 11/13/18   |          | 0.00      | 0.50    | Spray Paint           |           |
| 240         | QC                 | 1 pcs | 11/13/18   |          | 0.00      | 0.00    | QC14                  |           |
| 250         | HandFinish         | 1 pcs | 11/13/18   |          | 0.00      | 0.17    | HandFinish4           |           |
| 260         | QC                 | 1 pcs | 11/13/18   |          | 0.00      | 0.00    | QC5                   |           |
| 270         | Packaging          | 1 pcs | 11/13/18   |          | 0.00      | 0.00    | Packaging3            |           |
| 280         | DC                 | 1 pcs | 11/13/18   |          | 0.00      | 0.00    | DC                    |           |
| 290         | QC21-FG            | 1 Ea  | 11/13/18   |          | 0.00      | 0.00    | QC21                  |           |

Part Op 150 - 1-Remove bending marks longitudinally. \*\*\*Use Linemate\*\*\* 2-Identify as per note 6. 3-Insert skid tube in DT10416-  
 Descriptions: B, position tube so that bend sect. rest against DT10416. Bottom of FWD end against DT10416. Use clamp to hold  
 tube. \*\*\*BEND SECT. AND SADDLE MUST BE WITHIN 1 DEGREE OF TUBE C/L.\*\*\* Drill all pilot holes. Cleco as you  
 drill. 4-Open holes to finish size at section B-B, C-C and D-D 5- Cleco D5571-1 saddle in previously drilled pilot holes.  
 Transfer drill remaining saddle holes into D5611-1 skid tube. Open holes to finish size. \*\*\*SEE NOTE 11, SHEET 1,  
 THESE ARE THE ONLY TWO HOLES THAT CAN NOT BE OPEN TO SIZE\*\*\* 6-Cleco DT10432 on two previously drilled  
 FWD wear plate holes and drill remaining four FWD wear plate holes (SECT. E-E) Cleco DT10439 on two previously  
 drilled AFT wear plate holes and drill remaining four AFT wear plate holes (SECT. C-C) . 7-Open holes section C-C, D-D  
 and E-E to finished size. 8-Chamfer AFT end of tube as per DWG sheet 2 note 8. 9-Chamfer FWD end of tube as per  
 DWG sheet 2 note 9. 10-Open blade fitting holes and deburr as per note 5. Test fit blade fitting.  
 166 - ISSUE P/O PO041591 Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2  
 Attach copy of NDT results to work order NDT C OF C IS REQUIRED  
 170 - Ensure copy of NDT results attached to work order.  
 182 - 1-Prime inside & outside cross tube as per DWG sheet2 note 2 and QSI 005 4.2.1.3.3 BATCH: \_\_\_\_\_  
 190 - 1-Wet install saddle with Maxibolt rivets as per DWG sheet 1 note 8 and 9 \*\*\*EXCEPT THE TWO TOP HOLES.\*\*\*  
 Pro Seal PR-1764 B \_\_\_\_\_ EXP \_\_\_\_\_ \*\*\*VERY IMPORTANT TO LET A 12HR CURE TIME\*\*\* 2- As per  
 note 11 on sheet 1. Open the top remaining holes to size, use #8 drill (0.199") 3-Touch up Alodine the two holes with  
 ALODINE 600 4- Install the two remaining Maxibolt rivets as per dwg 5-Shave rivets as required. 6-Remove chips from  
 inside of tube and clean tube. Prepare for final inspection.  
 230 - 1-Prime inside & outside cross tube as per DWG sheet1 note 2 and QSI 005 4.2.1.3.3 BATCH: \_\_\_\_\_  
 \*\*\*NOTE\*\*\*do not paint inside saddle bore. Primer only. 2-Paint Outside of Tube as per DWG sheet 1 note 2 and Dart QSI  
 005 4.2.2.4 BATCH: \_\_\_\_\_  
 250 - Install inserts as per DWG sheet 1 note 10.  
 270 - Identify and pack for shipping as per PPP D130-1048-042 Location: \_\_\_\_\_ PPP Rev: \_\_\_\_\_  
 280 - Photocopy blue file & type labels per PPP D130-1048-042 CHG001

Outsource: 242 → PO041606 → CC 11-6-18

| Job BOM       |                 |               |                       |           |
|---------------|-----------------|---------------|-----------------------|-----------|
| Part / Item   | Component Name  | Quantity      | Operation             | Container |
| D5611-1       | EC130 Skid tube | 1 Ea (1 ea)   | 90-Start up Operation | 006344    |
| D5571-1       | Saddle          | 1 Ea (1 ea)   | 150-Skid tubes        | 511340    |
| CR7621S-06-05 | Rivet           | 22 Ea (22 ea) | 190-HandFinish        | 5118027   |
| ALS4-1032-225 | Rivnut          | 8 Ea (8 ea)   | 250-HandFinish        | 5102967   |
|               |                 |               |                       | 5059138   |

**Job Allocations**

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D5611-1        | 1        | 4         | 0         |
| 150-Skidtubes         | D5571-1        | 1        | 4         | 0         |
| 190-HandFinish        | CR7621S-06-05  | 22       | 421       | 0         |
| 250-HandFinish        | ALS4-1032-225  | 8        | 1,735     | 0         |

**Part Specifications**

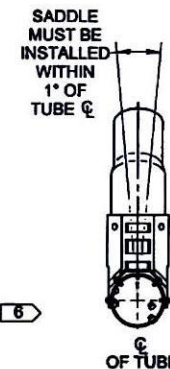
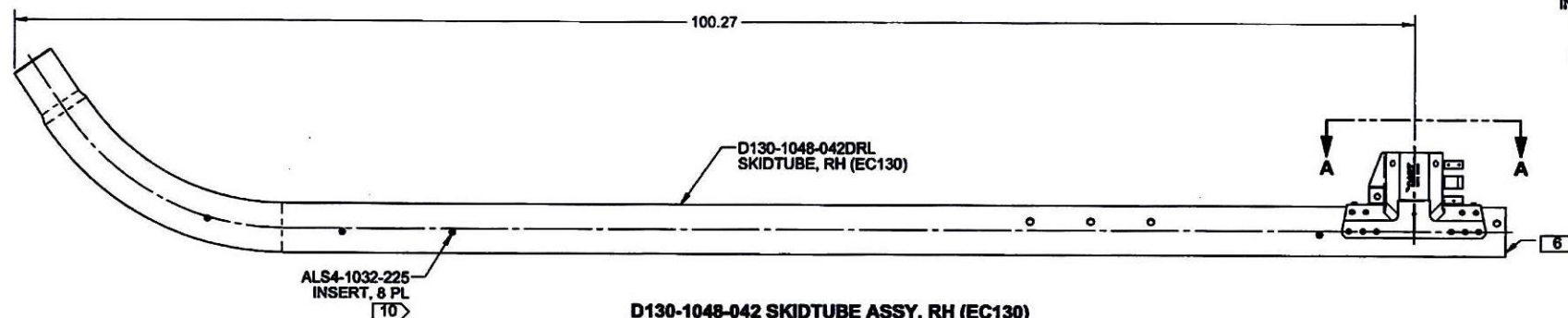
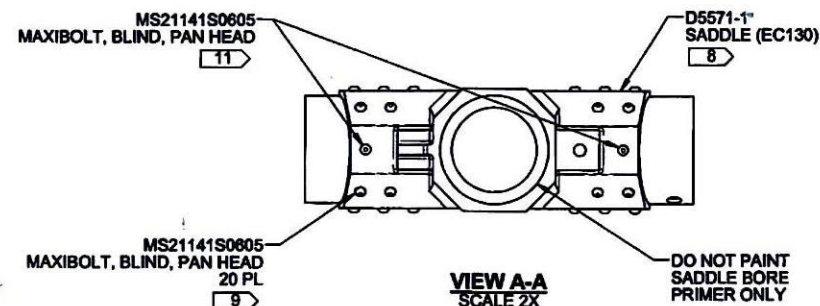
Specifications could not be found.

Plex 10/30/18 2:35 PM dart.white.jesse



| QTY<br>-042 | P/N              | DESCRIPTION                              |
|-------------|------------------|------------------------------------------|
| X           | D130-1048-042    | SKIDTUBE ASSY, RH (EC130)                |
| 1           | D130-1048-042DRL | SKIDTUBE, RH (EC130)                     |
| 1           | D5571-1          | SADDLE (EC130)                           |
| 22          | MS21141S0805     | MAXIBOLT, BLIND, PAN HEAD (CR7821S06-05) |
| 8           | ALS4-1032-225    | INSERT                                   |

W/P: 182414  
*[Signature]*



# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) AFTER ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D130-1048-042" AND S/N PER DART QSI 044 6.4 ON INSIDE OF TUBE, MAX 0.5" FROM AFT END OF TUBE
- 7) WEIGHT: 20.33 lbs
- 8) SEAL FAYING SURFACE WITH SIKAFLEX-241/-291 OR PROSEAL 890 OR EQUIVALENT MIL-S-8802 SEALANT
- 9) POSITION SADDLE AND TRANSFER DRILL  $\phi 0.193$  HOLE PATTERN FROM SADDLE ONTO SKIDTUBE. OPEN HOLES THRU SADDLE AND SKIDTUBE TO  $\phi 0.199 - \phi 0.202$ . TOUCH-UP HOLES WITH CHEMICAL FILM (ALODINE 1200) PER MIL-DTL-5541. WET INSTALL MAXIBOLTS WITH SIKAFLEX-241/-291 OR PROSEAL 890 OR EQUIVALENT MIL-S-8802 SEALANT
- 10) INSTALL ALS4 INSERTS IN EXISTING  $\phi 0.287$  HOLES
- 11) TRANSFER DRILL  $\phi 0.193$  HOLES FROM SADDLE TO SKIDTUBE. OPEN HOLES THRU SADDLE AND SKIDTUBE TO  $\phi 0.199 - \phi 0.202$ . ENSURE CLEAN HOLES FOR GOOD ELECTRICAL BONDING. TOUCH-UP HOLES WITH ELECTRICALLY CONDUCTIVE CHEMICAL FILM (ALODINE 600) PER MIL-DTL-5541. INSTALL MAXIBOLTS DRY (NO SEALANT).

RELEASED

2018 OCT 02  
 SCW 18-07 *[Signature]*

APPROVED

| REV.       | DESCRIPTION           | BY | DATE     |
|------------|-----------------------|----|----------|
| A          | NEW ISSUE             | ZF | 18.05.07 |
| DESIGN     | NO                    |    |          |
| DRAWN      | ZF                    |    |          |
| CHECKED    | MW                    |    |          |
| MFG. APPR. | JFS                   |    |          |
| APPROVED   | NO                    |    |          |
| DE APPR.   | CP <i>[Signature]</i> |    |          |
| DATE       | 18.05.07              |    |          |

**DART AEROSPACE LTD**  
 HAWKESBURY, ONTARIO, CANADA

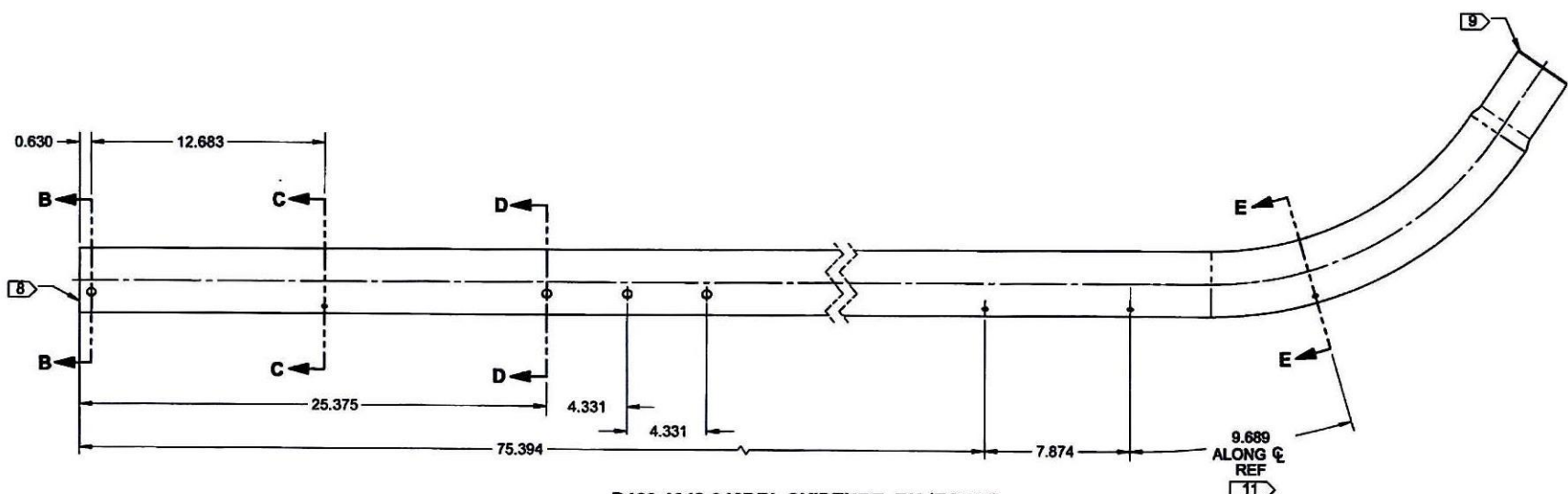
DRAWING NO.  
**D130-1048-042**

TITLE  
**SKIDTUBE, RH (EC130)**

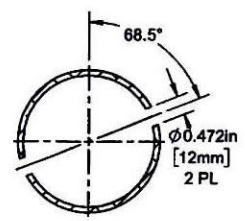
REV. A  
 SHEET 1 OF 2  
 SCALE  
 NTS

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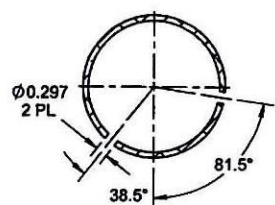
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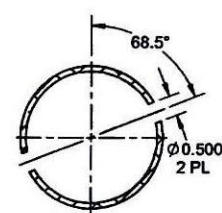
**D130-1048-042DRL SKIDTUBE, RH (EC130)**  
(DRILLING DETAIL)



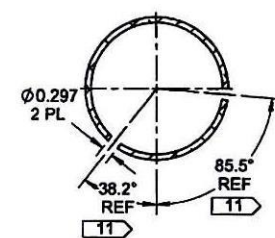
**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X, 3 PL



**SECTION D-D**  
SCALE 2X, 3 PL



**SECTION E-E**  
SCALE 2X

**NOTES:**

- 1) MATERIAL: MAKE FROM D5611-1
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 16.37 lbs
- 8) CHAMFER ID 0.06X0.06 WHERE INDICATED
- 9) CHAMFER OD 0.06X0.06 WHERE INDICATED
- 10) LIQUID PENETRANT INSPECT OUTSIDE SURFACE PER QSI 038 PRIOR TO DRILLING.
- 11) LOCATE HOLES USING DRILLING JIG DT10432.

RELEASED  
2018 OCT 02

APPROVED

|                                                                                                                                                                                                                                |          |                                        |              |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                         | NO       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                          | ZF       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                        | MW       | DRAWING NO.                            | REV. A       |
| MFG. APPR.                                                                                                                                                                                                                     | JFS      | <b>D130-1048-042</b>                   | SHEET 2 OF 2 |
| APPROVED                                                                                                                                                                                                                       | NO       | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                       | CP       | <b>SKIDTUBE, RH (EC130)</b>            | NTS          |
| DATE                                                                                                                                                                                                                           | 18.05.07 | COPYRIGHT © 2018 BY DART AEROSPACE LTD |              |
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8 7 6 5 4 3 2 1

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                         |  |                                                                                                                                                                                                                |  |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------|--|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| Job: <u>182414</u><br><br>Part No. <u>D130-1048-042</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | <b>DISPOSITION</b><br><br>Rework <input checked="" type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier Quality <input checked="" type="checkbox"/> </div> </div> |  |                                         |  |                                                                                                                                                                                                                |  |
| Date : <u>18-11-07</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  | Sequence #: <u>140150</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | QTY Affected : <u>1</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  | MRB (QSI042)<br>INSP 12 <u>18/11/07</u> |  |                                                                                                                                                                                                                |  |
| <b>Description Work Order Deviation</b><br><br><u>D5611-1 supplied un cut</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  | <b>Disposition</b><br><br><u>Cut tubes to length per D5611 Rev A. Total length should be 106.83</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |                                         |  | Completed By<br><br><div style="text-align: right;">           Lead hand / Supervisor<br/><br/> <u>DAS 9 9-89 18-11-07</u><br/><br/>           QC / QA Coordinator<br/><br/> <u>DAS 9 9-89 18-11-07</u> </div> |  |
| <b>Root Cause</b><br><br><div style="display: flex;"> <div style="flex: 1;">           Operator <input checked="" type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Preservation <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Human Factors <input type="checkbox"/> </div> <div style="flex: 1;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> </div> |  | <b>FAULT CATEGORY</b><br><br><div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input checked="" type="checkbox"/> Drill Holes<br/> <input checked="" type="checkbox"/> Fit/Function         </div> <div> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                         |  |                                                                                                                                                                                                                |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  | Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                         |  |                                                                                                                                                                                                                |  |





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **PO041591**

**Supplier:** SKY002-VC  
Skyservice  
6120 Midfield Road  
Mississauga  
ON  
L5P 1B1 Canada  
Phone: 905-678-5636  
Fax: 905-678-5841

**PO No:** PO041591  
**PO Date:** 11/5/18  
**Due Date:** 11/9/18  
**Purchase Order Revision:**  
**Revision Date:**  
**Ship-To Contact:** Phone:

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground  
**Pymt Terms:** Net 30  
**Freight Terms:**

**Special Comments:** please note po041568 was open an cancelfor the jobs same as po041591

## Items

| Line Item         | Job    | Part          | Description                                                                                                                                                                                                                      | Status | Account | Due Date | Order Quantity | Received Quantity | Balance  | Unit Price (CAD) | Extended Price  |
|-------------------|--------|---------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---------|----------|----------------|-------------------|----------|------------------|-----------------|
| 1                 | 181665 | D350-748-103  | AS350 / AS355 Stainless Steel Fwd Crosstube<br>: TC STC SH06-27 Issue 2,<br>FAA STC SR02359NY<br>11/03/04, EASA STC<br>EASA.10016903 Revision 2<br>10/09/03, BRAZIL 2009S04-04<br>09/04/06<br>ISSUE P/O TO SKY<br>SERVICE: _____ | Firmed | -       | 11/9/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$145.00/pcs     | \$145.00        |
| 2                 | 185582 | D130-1048-042 | EC130 Skidtube Assembly, RH<br>ISSUE<br>P/O: _____<br>Liquid Penetrant Inspection as<br>per QSI 038 LPI as per ASTM<br>1417 Level 2 Attach copy of<br>NDT results to work order NDT<br>C OF C IS REQUIRED                        | Firmed | -       | 11/9/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$133.75/pcs     | \$133.75        |
|                   | 185581 |               |                                                                                                                                                                                                                                  | Firmed | -       | 11/9/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$133.75/pcs     | \$133.75        |
| <b>Sub Total:</b> |        |               |                                                                                                                                                                                                                                  |        |         |          | <b>2</b>       | <b>0</b>          | <b>2</b> |                  | <b>\$267.50</b> |

Plex 11/5/18 1:00 PM dart.lavoie.chanta

DAS  
68  
9-89



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **PO041591**

## **Items**

| Line Item           | Job    | Part          | Description                                                                                                                                                                                                                         | Status | Account | Due Date | Order Quantity | Received Quantity | Balance  | Unit Price (CAD)  | Extended Price  |
|---------------------|--------|---------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---------|----------|----------------|-------------------|----------|-------------------|-----------------|
| 3                   | 185578 | D130-1048-041 | EC130 Skidtube Assembly, LH<br>ISSUE<br>P/O:<br>Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED                                             | Firmed | -       | 11/9/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$133.75/pcs      | \$133.75        |
|                     | 185580 |               | 1 X NOV 05 2018                                                                                                                                                                                                                     | Firmed | -       | 11/9/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$133.75/pcs      | \$133.75        |
| <b>Sub Total:</b>   |        |               |                                                                                                                                                                                                                                     |        |         |          | <b>2</b>       | <b>0</b>          | <b>2</b> |                   | <b>\$267.50</b> |
| 4                   | 182064 | D130-1048-141 | EC130 Fwd Crosstube<br>*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***<br>ISSUE<br>P/O:<br>Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED | Firmed | -       | 11/9/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$133.75/pcs      | \$133.75        |
|                     | 182059 |               | 1 X NOV 05 2018                                                                                                                                                                                                                     | Firmed | -       | 11/9/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$133.75/pcs      | \$133.75        |
| <b>Sub Total:</b>   |        |               |                                                                                                                                                                                                                                     |        |         |          | <b>2</b>       | <b>0</b>          | <b>2</b> |                   | <b>\$267.50</b> |
| 5                   | 182056 | D130-1048-241 | EC130 Aft Crosstube<br>*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***<br>ISSUE<br>P/O:<br>Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED | Firmed | -       | 11/9/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$75.00/pcs       | \$75.00         |
|                     | 182057 |               | 1 X NOV 05 2018                                                                                                                                                                                                                     | Firmed | -       | 11/9/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$75.00/pcs       | \$75.00         |
| <b>Sub Total:</b>   |        |               |                                                                                                                                                                                                                                     |        |         |          | <b>2</b>       | <b>0</b>          | <b>2</b> |                   | <b>\$150.00</b> |
| <b>Grand Total:</b> |        |               |                                                                                                                                                                                                                                     |        |         |          |                |                   |          | <b>\$1,097.50</b> |                 |

Plex 11/5/18 1:00 PM dart.lavoie.chantal





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

## PURCHASE ORDER PO041591

### Order Notes

#### Procurement Quality Clauses

A005 right of entry  
A012 chemical and physical test report  
A016 personnel qualification  
A017 raw material identification (as applicable)

A022 Apical Processing  
A024 process certifications  
A026 certification of material conformance

A041 quality management system  
A042 dart notification by supplier  
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

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**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

|                          |                                      |                      |                               |
|--------------------------|--------------------------------------|----------------------|-------------------------------|
| <b>WO #:</b> MWO38034    | <b>Customer:</b> Dart Aerospace Ltd. | <b>Dept:</b> NDT YUL | <b>Reference:</b> PO041568 ✓  |
| <b>Descr:</b>            | <b>PN:</b>                           | <b>S/N:</b>          | <b>Qty:</b> 1 <i>PO041591</i> |
| <b>Make:</b>             | <b>Model:</b>                        | <b>Reg:</b>          | <b>A/C S/N:</b>               |
| <b>TSN:</b>              | <b>CSN:</b>                          | <b>TSO:</b>          |                               |
| <b>Task:</b> UNSCHEDULED |                                      |                      | <b>Sequence:</b> 1            |

**Work Required:**

CARRY OUT NDT (LIQUID PENETRANT CRACK TEST) ON THE FOLLOWING 5 CROSSTUBES AND 4 SKIDTUBES :

P/N: D130-1048-141 FWD CROSSTUBE

1- JOB SHEET# 182064 ✓ 2- JOB SHEET# 182059 ✓

P/N: D130-1048-241 AFT CROSSTUBE

3- JOB SHEET# 182056 ✓ 4- JOB SHEET# 182057 ✓

P/N: P/N: D350-748-103 FWD CROSSTUBE

5- JOB SHEET# 181665 ✓

P/N: P/N: D130-1048-041 EC130 SKIDTUBE LH

6- JOB SHEET# 185580 ✓ 7- JOB SHEET# 185578 ✓

P/N: P/N: D130-1048-042 EC130 SKIDTUBE RH

8- JOB SHEET# 185581 ✓ 9- JOB SHEET# 185582 ✓

DAS  
68  
9-89

|                                                                                               |                   |                       |
|-----------------------------------------------------------------------------------------------|-------------------|-----------------------|
| <b>Action Taken:</b>                                                                          | <b>Date:</b>      | <b>Initial/Stamp:</b> |
| LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-9) AS PER ASTM1417M-16 |                   |                       |
| -NO CRACK FOUND.                                                                              | <i>2 NOV 2018</i> |                       |
| PEN.(ZL-56, MPO13600), DEV.(SKD-S2, MPO11715), CLEANER(SKC-S, MPO MPO19368)                   |                   |                       |
| <b>Description</b>                                                                            | <b>Location</b>   | <b>P/N</b>            |
| <b>Qty</b>                                                                                    | <b>Batch</b>      | <b>S/N Off</b>        |
| <b>S/N On</b>                                                                                 |                   |                       |
|                                                                                               |                   |                       |
|                                                                                               |                   |                       |
|                                                                                               |                   |                       |
|                                                                                               |                   |                       |
|                                                                                               |                   |                       |

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

|                              |                       |                                |
|------------------------------|-----------------------|--------------------------------|
| <b>Signature:</b>            | <b>ACA/SCA Stamp:</b> | <b>Date:</b> <i>2 NOV 2018</i> |
| <b>Name:</b> CHRISTIAN BRIEN |                       |                                |



|                          |        |
|--------------------------|--------|
| <b>Via:</b>              | Ground |
| <b>Pymt Terms:</b>       | Net 30 |
| <b>Freight Terms:</b>    |        |
| <b>Special Comments:</b> |        |

[https://www.plexonline.com/325258d8-1aa9-47d0-888c-8205811242f4/Plexus\\_Control/Report\\_Viewr\\_2.asp?rv=u%1E..%2FPurchasing%2FPO](https://www.plexonline.com/325258d8-1aa9-47d0-888c-8205811242f4/Plexus_Control/Report_Viewr_2.asp?rv=u%1E..%2FPurchasing%2FPO) Print... 1/2





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER

## PO041606

| Items        |        |               |                                                                                                                                                                                                                                                                                                                                                                                                                                    |        |         |          |                |                   |         |                  |                |
|--------------|--------|---------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---------|----------|----------------|-------------------|---------|------------------|----------------|
| Line Item    | Job    | Part          | Description                                                                                                                                                                                                                                                                                                                                                                                                                        | Status | Account | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
| 2            | 185578 | D130-1048-041 | EC130 Skidtube Assembly, LH<br>Issue P/O to Atelier<br>Debosselage: _____<br><br>***MASK PRIOR TO PRIME<br>AND PAINT AS PER NOTE<br>g***<br><br>*** WEAR LATEX GLOVES<br>WHEN HANDLING<br>CROSSTUBE***<br><br>***NOTE***do not paint inside<br>saddle bore. Primer only.<br><br>1- PRIME INSIDE AND<br>OUTSIDE PER DWG (FLOAT<br>SKIDTUBE PRIMER)<br><br>2- PAINT OUTSIDE<br>SURFACE AS PER DWG<br>NOTE2 (FLOAT SKIDTUBE<br>PAINT) | Firmed | -       | 11/9/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$225.00/pcs     | \$225.00       |
|              | 185580 |               |                                                                                                                                                                                                                                                                                                                                                                                                                                    | Firmed | -       | 11/9/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$225.00/pcs     | \$225.00       |
| Sub Total:   |        |               |                                                                                                                                                                                                                                                                                                                                                                                                                                    |        |         |          | 2              | 0                 | 2       |                  | \$450.00       |
| Grand Total: |        |               |                                                                                                                                                                                                                                                                                                                                                                                                                                    |        |         |          |                |                   |         | \$900.00         |                |

### Order Notes

Procurement Quality Clauses  
A005 right of entry  
A012 chemical and physical test report  
A016 personnel qualification  
A017 raw material identification (as applicable)

A022 Apical Processing  
A024 process certifications  
A026 certification of material conformance

A041 quality management system  
A042 dart notification by supplier  
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

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Plex 11/6/18 8:41 AM dart.tsimiklis.chrisoula